

# Work Order ID 53665

November 12, 2009 8:06:46 AM



Page 1

Item ID: D2221

Accept



Setup Start



Revision ID: H

Stop



Item Name: 350 Basket Base

Start Date: 12/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 19/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: RF Date: 09-11-12 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2221	Rev H

100 Large Fab 0.00



Large Fab

Memo

0.00

Large Fab

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221  
2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221  
3- tack weld mesh on basket as per dwg D2221  
A/R ER316 S.S. Rod Batch: M109213

PD 09 11 24

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

PD 09.11.24

# Work Order ID 53665

November 12, 2009 8:06:46 AM



Page 2

Item ID: D2221

Accept



Setup Start



Revision ID: H

Stop



Item Name: 350 Basket Base

Start Date: 12/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 19/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC6- Inspect dimensions to drawing

0.00

⇒ S 02/11/24



QC

Memo

0.00

Quality Control



130

\* PRESSURE WASH  
White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel  
M112 148

0.00

⇒ H 02/11/26



Powdercoat

Memo

0.00

Powder Coating

1- Plug holes prior to

1ST COAT:

START TIME: 1:24:50pm

OVEN TEMPERATURE: 400°F

FINISH TIME: 2:15pm

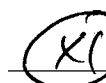
\*\*\*\*\* 2nd coat if necessary\*\*\*\*\*

2ND COAT:

START TIME: 2:30pm

OVEN TEMPERATURE: 400°F

FINISH TIME: 3:00pm



# Work Order ID 53665

November 12, 2009 8:06:46 AM



Page 3

Item ID: D2221

Accept



Setup Start



Revision ID: H

Stop



Item Name: 350 Basket Base

Start Date: 12/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 19/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

MO 09/11/27

X1

150

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

W/O 53646

1

09-11-27

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/09

MO 09-12-1

①

# Picklist Print

November 12, 2009 8:08:01 AM

Page 1

Work Order ID: 53665

Parent Item: D2221RevH

Parent Item Name: 350 Basket Base


Comments: ADD INDENTIFY AND STOCK DD 09.11.05 verified by:JLM

Start Date: 12/11/2009

Required Date: 19/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq.ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2221-1RevH  Rib		Manufactured	No			100	Each	14.0000	1.0000			

*Cpl 09.11.24*

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1	
48101	1	
Main Warehouse		
WA	13	
51872	1	
53213	12	

D2221-5RevH



Rib

Manufactured No

100 Each 8.0000 2.0000



① ✓

*Cpl 09.11.24*

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	8	
53244	8	

D2221-7RevH



Rib

Manufactured No

100 Each 4.0000 1.0000



② ✓

*Cpl 09.11.24*

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
WA	4	
53246	4	

① ✓

# Picklist Print

November 12, 2009 8:08:01 AM

Work Order ID: 53665



Parent Item: D2221RevH

Parent Item Name: 350 Basket Base

Start Date: 12/11/2009

Required Date: 19/11/2009

Comments: ADD INDENTIFY AND STOCK DD 09.11.05 verified by: JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2232-3RevC		Manufactured	No			100	Each	15.0000	2.0000			
Basket Hinge												

*pl 09.11.24*

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

2

50024

2

Main Warehouse

WA

13

53344

13

*② ✓*

D2235-1RevB1

Manufactured No

100

Each

14.0000

2.0000



Basket Rib



*pl 09.11.24*

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

10

53215

10

Main Warehouse

WA

4

50565

3

51871

1

*① ✓*

*353660 → ① ✓*

# Picklist Print

November 12, 2009 8:08:01 AM

Work Order ID: 53665



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 12/11/2009

Required Date: 19/11/2009

Comments: ADD IDENTIFY AND STOCK DD 09.11.05 verified by:JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581RevA1  Mounting Bracket		Manufactured	No			100	Each	40.0000	2.0000			

*pl 09.11.24*

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 12

46086 2

48428 1

51120 9

Main Warehouse

WA 28

50872 1

51745 27

D3442-1RevA

Manufactured No



Shim

100 Each 20.0000 2.0000



*pl 09.11.24*

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 1

46767 1

Main Warehouse

WA 19

50951 7

53386 12

*pl 09.11.24*

# Picklist Print

November 12, 2009 8:08:01 AM

Work Order ID: 53665



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 12/11/2009

Required Date: 19/11/2009

Comments: ADD INDENTIFY AND STOCK DD 09.11.05 verified by:JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3825-041RevA		Manufactured	No			100	Each	4.0000	2.0000			
Rib Assembly (Basket End)												

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse  
WA  
53381

4  
4

*Pl 09.11.24*

D3826-041RevB		Manufactured	No			100	Each	4.0000	2.0000			
Rib / Gusset Assembly												

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse  
WA  
53216

4  
4

*②✓*  
*Pl 09.11.24*

D3827-041RevA		Manufactured	No			100	Each	4.0000	1.0000			
Rib Assembly (Inboard)												

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse  
ST  
53247

4  
4

*353500 → ②✓*  
*Pl 09.11.24*  
*①✓*

# Picklist Print

November 12, 2009 8:08:01 AM

Work Order ID: 53665



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 12/11/2009

Required Date: 19/11/2009

Comments: ADD IDENTIFY AND STOCK DD 09.11.05 verified by:JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3832-1RevA		Manufactured	No			100	Each	4.0000	1.0000			
Mesh (Base)												

*09.11.24*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2

46306

1

46774

1

Main Warehouse

WA

2

53218

2

*B53626 \*①✓*

D3833-1RevA

Manufactured No



Mesh (Base Erid Face)

100

Each

6.0000

2.0000



*09.11.24*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

6

50025

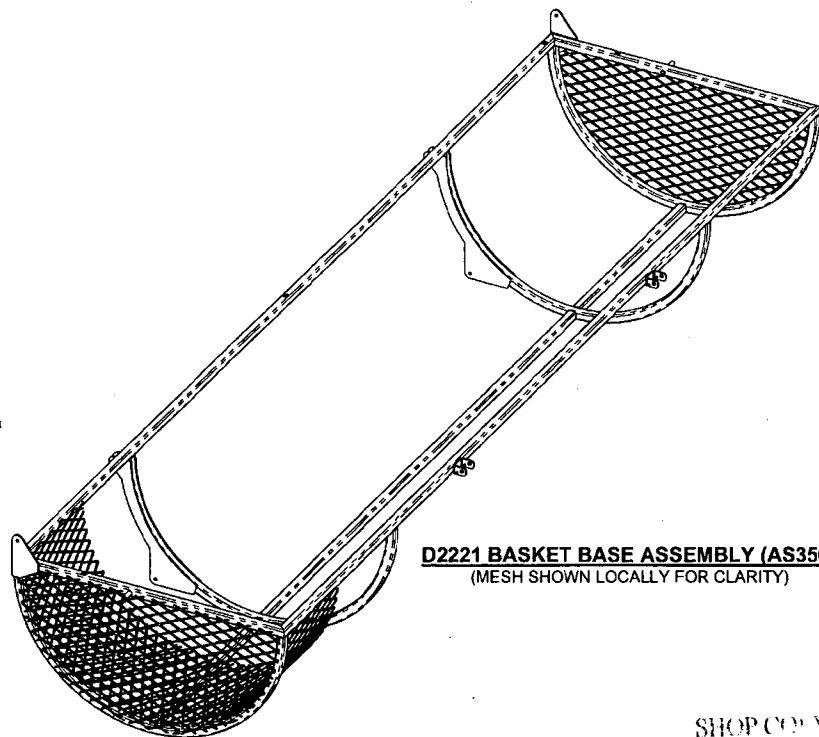
2

53214

4

*B53627 → ②✓*





**D2221 BASKET BASE ASSEMBLY (AS350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT RETURN  
WORK ORDER  
NO. 53445  
1309-11-12

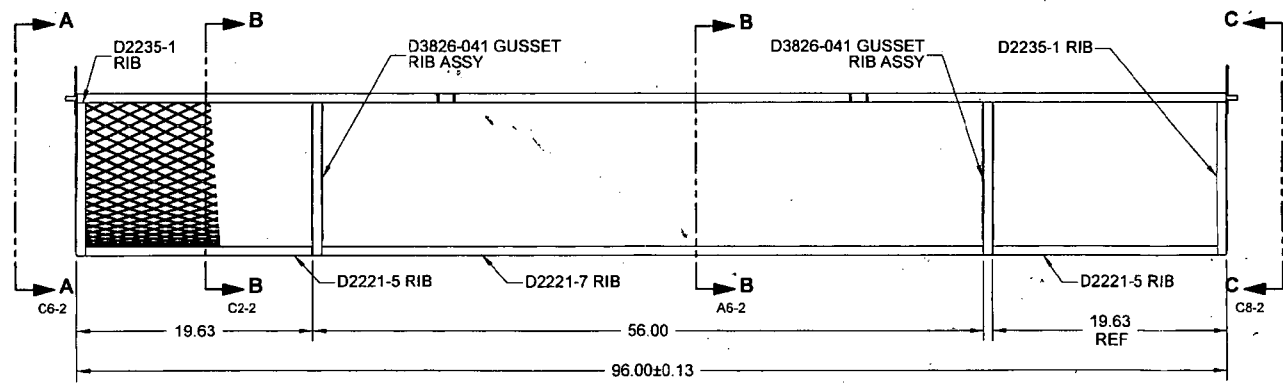
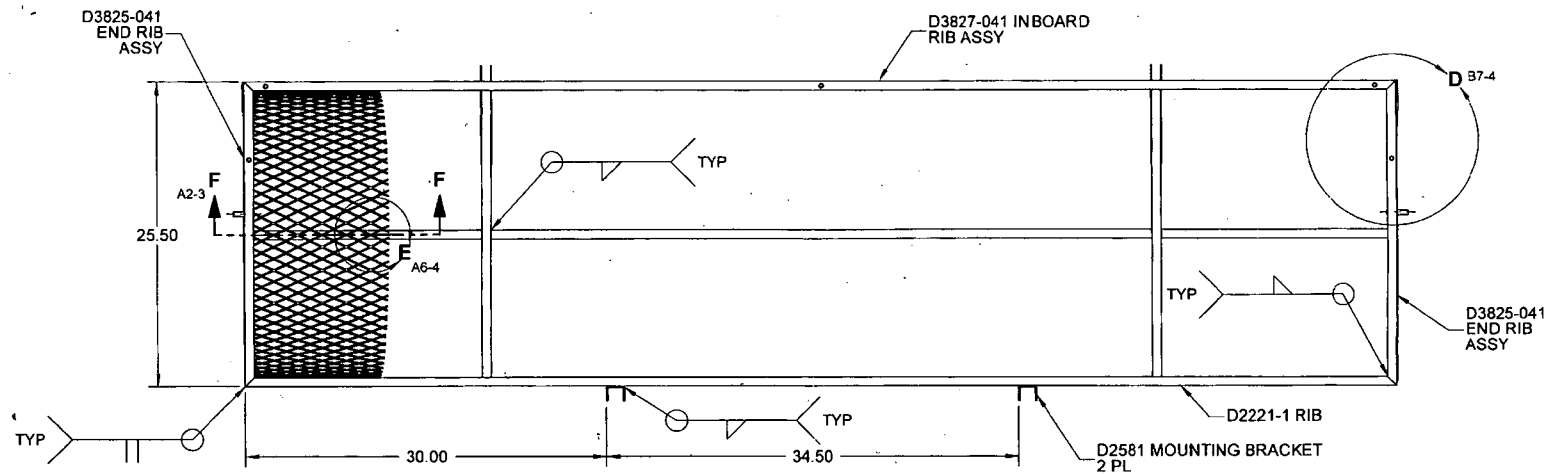
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 42.00 lbs APPROX
- 8) MASK ALL HOLES PRIOR TO POWDER COATING

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

RELEASED  
08/11/18

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS $\pm 0.01$ AND 56.00 DIM WAS REF (ZN B6-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JS		
CHECKED	JS	DRAWING NO.	REV. H
MFG. APPR.	JS	D2221	SHEET 1 OF 5
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1984 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

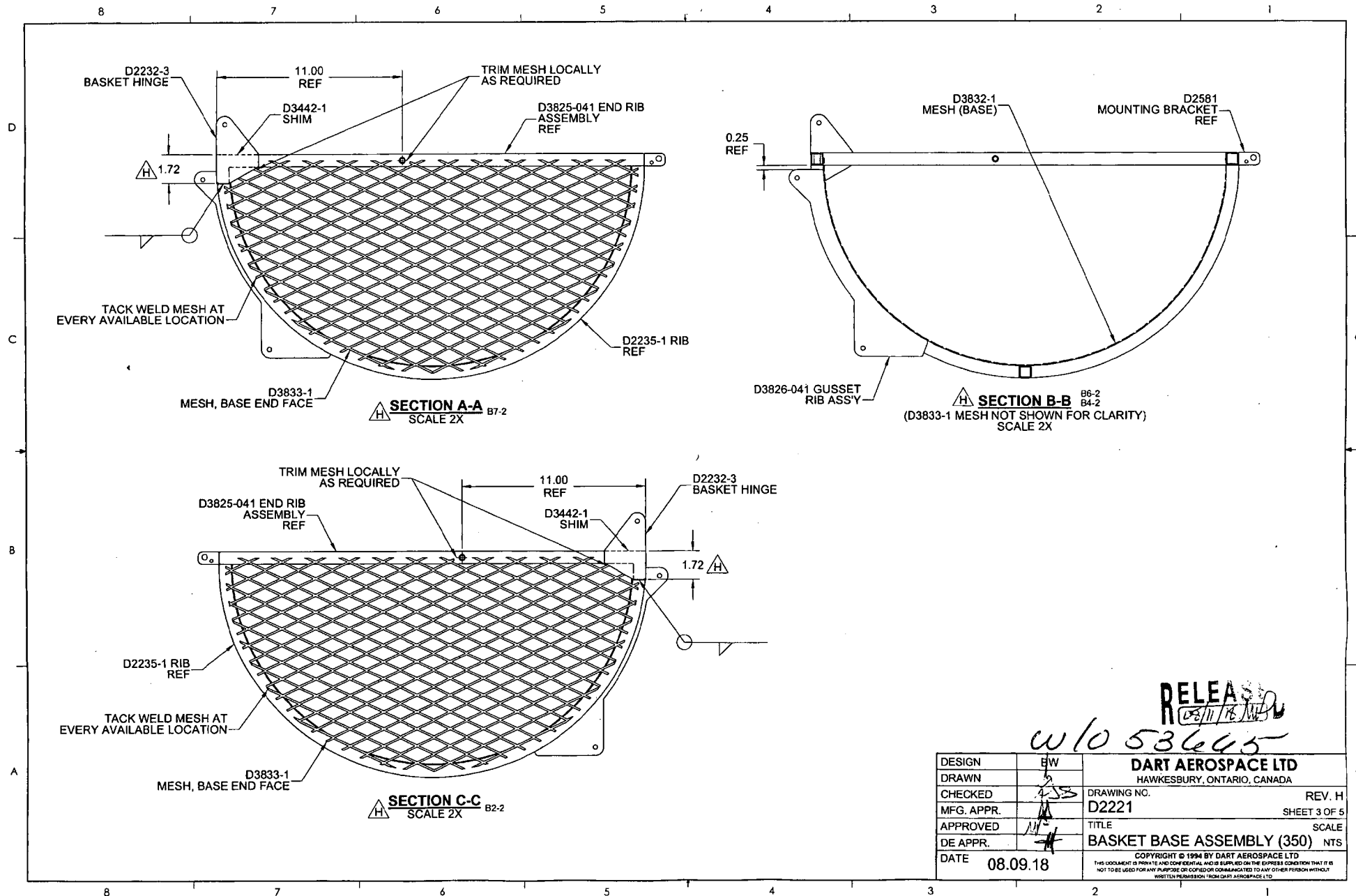


**D2221 BASKET BASE ASSEMBLY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**RELEASED**  
06/11/18

*w/10 53465*

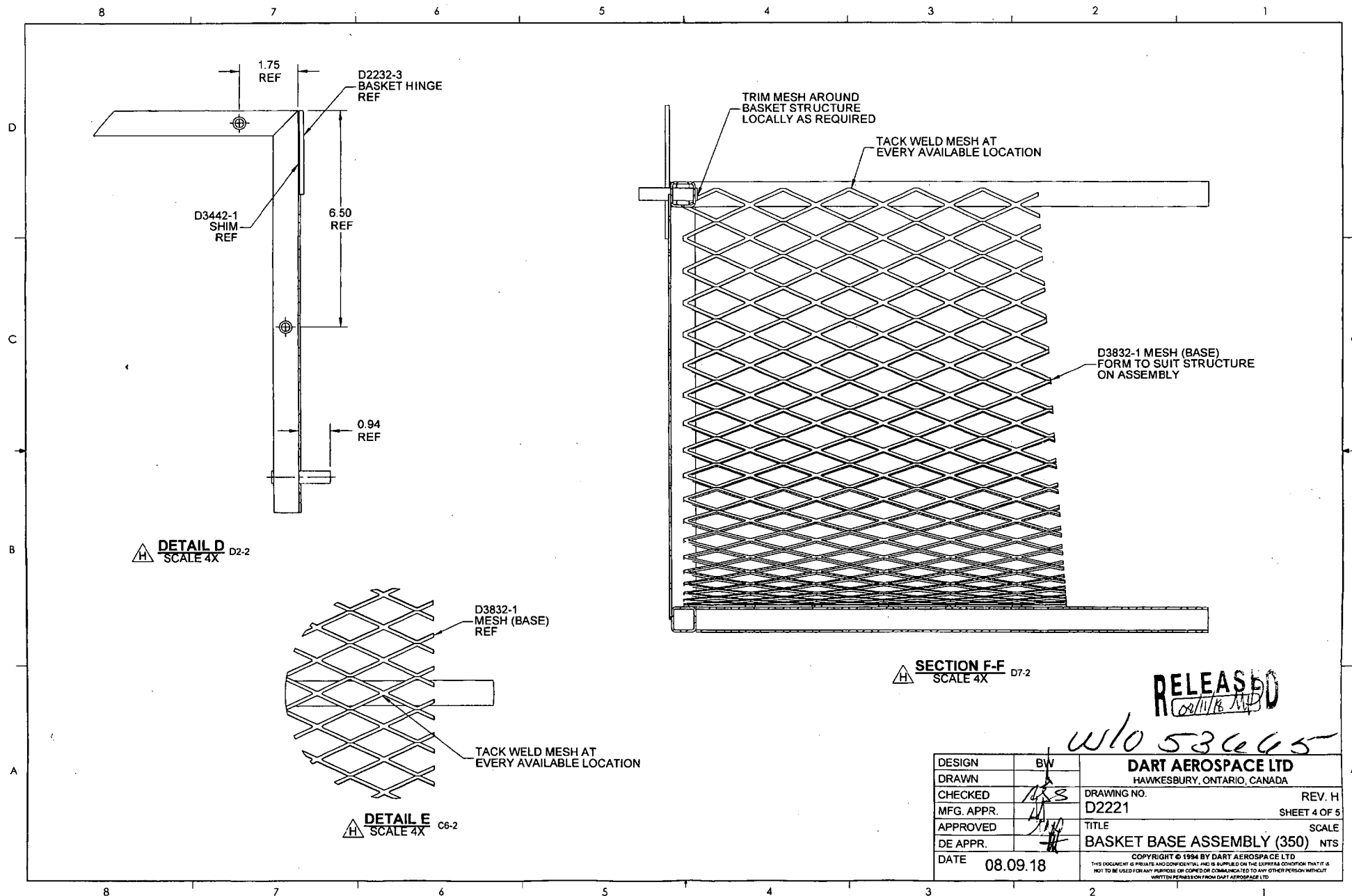
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>	DRAWING NO.	REV. H
CHECKED	<i>[Signature]</i>	D2221	SHEET 2 OF 5
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	BASKET BASE ASSEMBLY (350) NTS	
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 1984 BY DART AEROSPACE LTD	
DATE	08.09.18	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

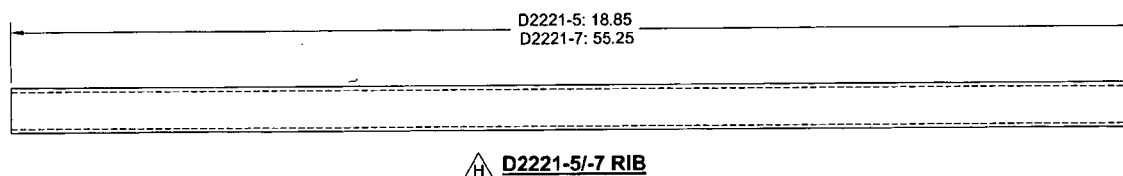
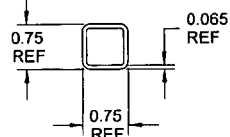
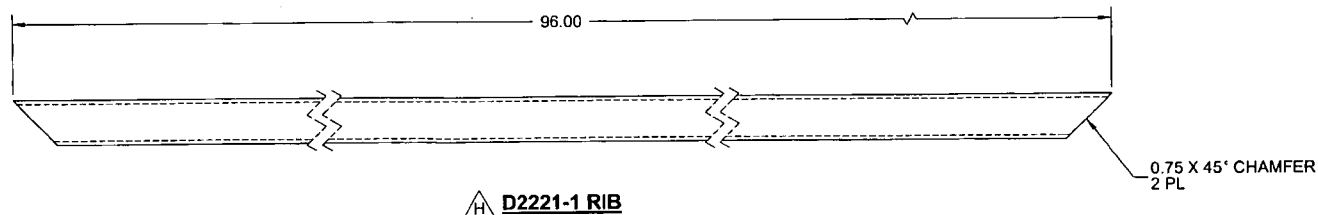
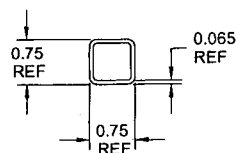


RELEASE  
02/11/18

W10 53645

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	5	HAWKESBURY, ONTARIO, CANADA	
CHECKED	435	DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 3 OF 5
APPROVED	11	TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	





# NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2221-1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS		
CHECKED	AS	DRAWING NO.	REV. H
MFG. APPR.	AS	D2221	SHEET 5 OF 5
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

RELEASED  
06/11/18

W1053665